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मानक

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Mazdoor Kisan Shakti Sangathan

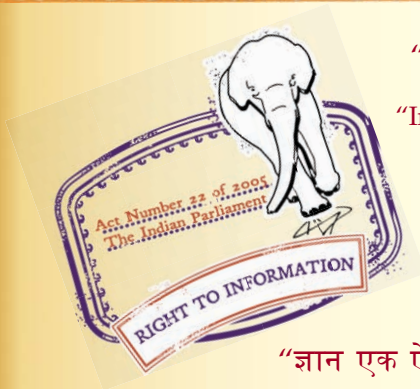
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“Step Out From the Old to the New”

IS 7511-10 (1991): Dimensions For Neck Finishes, Part 10: Continuous screw thread for use with plastic cap [CHD 10: Glassware]



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Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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भारतीय मानक

नेक फिनिश के लिए आयाम

भाग 10 प्लास्टिक कैप के साथ प्रयुक्त सनत पेंच चूड़ियां

Indian Standard

DIMENSIONS FOR NECK FINISHES

PART 10 CONTINUOUS SCREW THREAD FOR USE WITH PLASTIC CAPS

UDC 621.978.147 : 666.171.92 : 006.78

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FOREWORD

This Indian Standard was adopted by the Bureau of Indian Standards after the draft finalized by the Glassware Sectional Committee had been approved by the Chemical Division Council.

A variety of glass finishes are now being produced by the Glass Container Industry. Most of these finishes are being used by packers who have facilities for high speed filling and capping operations. Consequently, it has become necessary to standardize the dimensions of different type of glass finishes.

This standard, first issued in 1974, was revised in 1986 into the following 8 parts:

- Part 1 Shallow continuous thread finish (R 3)
- Part 2 Shallow continuous deep thread finish for deep screw caps (R 3/D)
- Part 3 Roll-on threads non-pilferproof (RONPP)
- Part 4 Roll-on threads pilferproof (ROSPP)
- Part 5 Vial goldie seal glass finishes
- Part 6 Dual neck finish
- Part 7 Crown finish,
- Part 8 Vacuum lug finish

Subsequently the proposed Part 9 of this Indian Standard on dimensions for 28 mm finishes for pressurised liquids was issued.

This Indian Standard prescribes the dimensions for glass container neck finishes of continuous screw thread type with different nominal diameters used for instant coffee jars sealed with plastic screw caps integrally assembled with tamper evident secondary seals. The second seal eventually gets transferred to the glass sealing surface after the first removal of the cap, leaving a tear-off diaphragm. This will form part 10 of IS 7511.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (revised)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*Indian Standard***DIMENSIONS FOR NECK FINISHES****PART 10 CONTINUOUS SCREW THREAD FOR USE WITH PLASTIC CAPS****1 SCOPE**

This Indian Standard prescribes the dimensions for glass container neck finishes of continuous screw thread type used for instant coffee jars, sealed with plastic screw caps integrally assembled with tamper evident secondary seals.

2 REFERENCE

The following Indian standards have been referred to in this Standard:

| <i>IS No</i> | <i>Title</i> |
|------------------------|---|
| 1382 : 1981 | Glossary of terms relating to glass and glassware (<i>first revision</i>) |
| 6654 : 1982 | Glossary of terms relating to glass containers (<i>first revision</i>) |
| 7511 (Part 1) : 1986 | Dimensions for neck finishes: Part 1 Shallow continuous thread finish (<i>first revision</i>) |

3 TERMINOLOGY

For the purpose of this standard the definitions as given in IS 1382 : 1981 and IS 6654 : 1982 shall apply.

4 DIMENSIONS

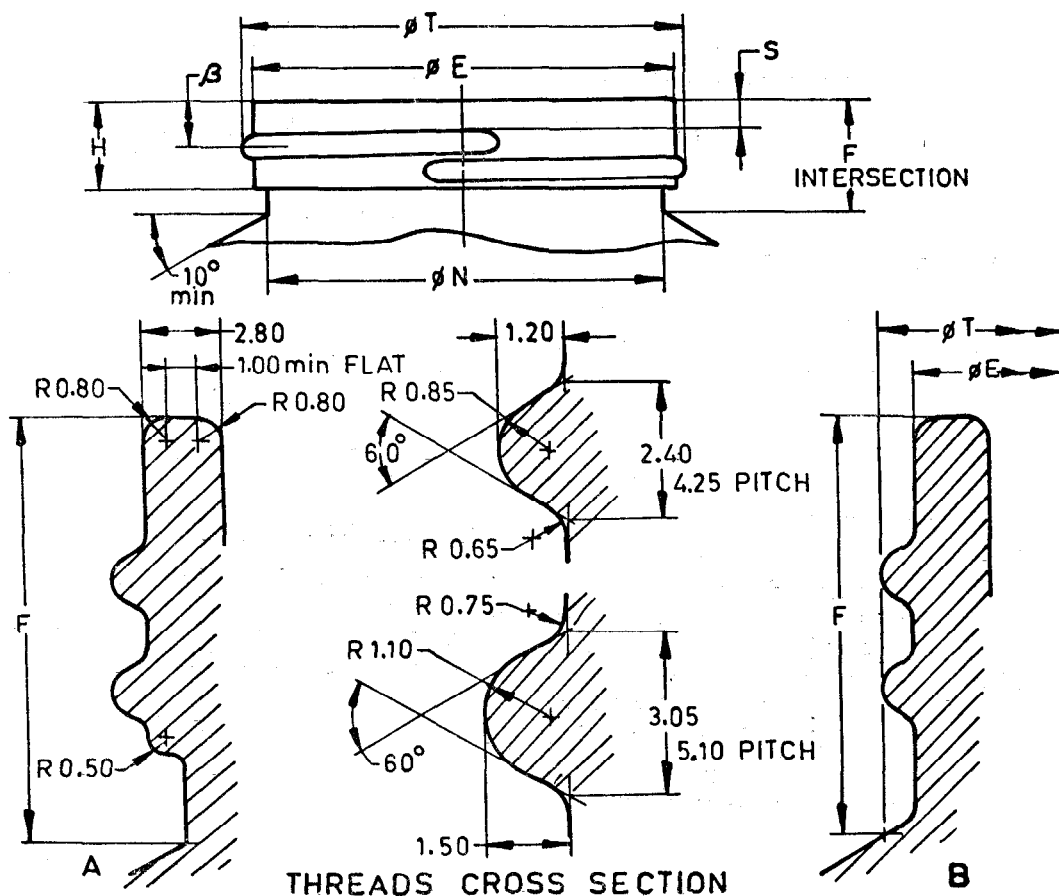
The continuous screw thread glass neck finishes shall have the shoulder, thread and sealing surface profiles and dimensions as detailed in Table 1.

5 CHECKING AND INSPECTION

All the essential dimensions may be checked by any appropriate method. The procedure of gauging and the gauges employed may be as detailed in Fig. 1 of IS 7511 (Part 1) : 1986.

Table 1 Dimensions for Continuous Screw Thread Finish for use with Plastic Caps

All dimensions in millimetres.



THREADS CROSS SECTION

| No. or Size | T | | E | | H | F | S | | N | β See Note 1 | Cutter Dia | Pitch |
|-------------------|-------|-------|-------|-------|-------|-------|------|------|-------|--------------------------|---------------|-------|
| | Max | Min | Max | Min | | Min | Max | Min | | | | |
| 43 | 41.95 | 41.10 | 39.55 | 38.70 | 11.90 | 15.50 | 4.90 | 4.10 | 36.60 | 1° 41' | 12.70 | 4.25 |
| 48 | 47.45 | 46.60 | 45.05 | 44.20 | 11.90 | 15.50 | 4.90 | 4.10 | 42.00 | 1° 36' | 12.70 | 4.25 |
| 53 | 52.45 | 51.60 | 50.05 | 49.20 | 11.90 | 15.50 | 4.90 | 4.10 | 47.00 | 1° 31' | 12.70 | 4.25 |
| 58 | 56.45 | 55.60 | 54.05 | 53.20 | 11.90 | 15.50 | 4.90 | 4.10 | 51.00 | 1° 25' | 12.70 | 4.25 |
| 60 | 59.45 | 58.60 | 57.05 | 56.20 | 11.90 | 15.50 | 4.90 | 4.10 | 54.00 | 1° 20' | 12.70 | 4.25 |
| 66 | 65.45 | 64.60 | 63.05 | 62.20 | 11.90 | 15.50 | 4.90 | 4.10 | 59.50 | 1° 14' | 12.70 | 4.25 |
| 70 | 69.45 | 68.60 | 67.05 | 66.20 | 11.90 | 15.50 | 4.90 | 4.10 | 64.30 | 1° 8' | 12.70 | 4.25 |
| 80 | 79.65 | 78.65 | 76.60 | 75.60 | 12.50 | 15.50 | 3.45 | 2.65 | 73.50 | 1° 12' | 12.70 | 5.10 |
| 83 | 83.00 | 82.00 | 79.95 | 78.95 | 12.50 | 15.50 | 3.45 | 2.65 | 77.00 | 1° 9' | 12.70 | 5.10 |
| 90 | 90.25 | 89.25 | 87.20 | 86.20 | 13.40 | 17.0 | 4.90 | 4.10 | 84.20 | 1° 3' | 12.70 | 5.10 |

NOTES

- β = Helix angle or angle of fixture to cutter, $\tan \beta = \frac{\text{Pitch}}{\pi (\text{mean between mean } T \text{ and mean } E \text{ diameters})}$
- Depressed threads are optional.
- Fig. 1 B shows optional thread transfer.
- Minimum of 1 turn full depth of thread.

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Doc : No. CHD 10 (0931)

Amendments Issued Since Publication

| Amend No. | Date of Issue | Text Affected |
|-----------|---------------|---------------|
| | | |
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